Work Order ID 105183 05183* Page 1 Thursday, July 25, 2013 3:17:18 PM Item ID: D3052-1 Accept *N900040100* Setup Start **Revision ID:** Item Name: Mounting Lug **Start Date:** 7/25/2013 Start Qty: 1.00 **Cust Item ID:** Required Date: 7/31/2013 Req'd Qty: 1.00 **Customer:** Reference: RA 111569 Run Process Plan: WWF. Date: 13-7-25 Tooling: **Approvals:** Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Accept Reject Insp. Work Center ID Description **Run Hours** Qty Code **Qty** Number Stamp Draw Nbr Revision Nbr D3052 Rev B 190 0.00 *190* OC 0.00 Memo Quality Control INSPECT RA 111569 D3052-1 X 1 B40200 STRIP AND RE-POWDERCOAT 200 Chemical Conversion Coat per QSI005 4.1 0.00 *200* HandFinish 0.00 Memo Hand Finishing STRIP AND RE-ALODINE

210

QC

Quality Control

QC7-Inspect Chemical Conversion Coat

Memo

0.00

0.00

1x g m f 13/07/31

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

	,, ,,								QA Closed:	Date	e:
Work Order	•				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part No				-	Rework Scrap		Skid-tube Machining	Crosstube Small Fab	4	Water Jet d. Eng. Coor.	Engineering Quality
NCR No)				Use-as-is Work Order Update] Th€	rmoforming Large Fab	FinishingComposite	Rec/Sto	re/Packaging Supplier	Other
Root				Descri	ption of work order update	Initia	A	ction	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Chief E	ng Des	cription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved											
*	· • · · · · · · · · · · · · · · · · · ·	•			F	AULT CA	TEGORY				
Landing	g Gear				General				_		
	Bending Centre No Cracks Crushed/ Cuffs	Crimped	ntric to (o/s	Bend BOM/Route Broken/Damaged Burrs Contamination	Inspe Instr Mai	ware ection Incomplete uctions Incomplete ntenance	/Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved	ct issing	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled
_	Heat Trea			<u> </u>	Countersink	\vdash	abeled	<u> </u>	Positioned V		-
	Inspectio	-	Tube	<u> </u>	Cut Too Short	Misr			Power Loss/	'Surge	Other
	Ripples in			<u> </u>	Drill Holes	Offse					
 -	Torque W			n	Drawing	\vdash	of Calibration		***		
_	Turning S			\vdash	Finish	\vdash	of Sequence				
1	Wave/Tw	rist in Tul	oe e	j	Folio	Outs	ide Dimensions				

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Powder Coating

OC

Quality Control

QC3- Inspect Part Finish

All parts must be Retru to ED.

0.00

Memo

B105180

0.00

Packaging

Packaging

240

230

240

Identify as per dwg & Stock Location:

D205-541-044

													DQA:	Date	
NCR: Y	es	/ No					WORK ORDER NON-C	O	NFORN	/ANCE / UP	DATE	0	A Closed:	Date	3.
									•						
Nork Orde	r:						DISPOSITION		•		AGAINST I	DEPA	ARTMENT/	PROCESS	
Part N	-						Rework Scrap		Skid-tube Crosstube Machining Small Fab			Water Jet Prod. Eng. Coor.			Engineering Quality
NCR N	NCR No.						Use-as-is Thermoforming Work Order Update Large Fab				Finishing Composite				Other
Root			·		Desc	rip	otion of work order update	Ī	nitial	Ac	tion		Sign &		
Cause		Date	Step	Qty		С	or Non-conformance	Ch	ief Eng	Desc	ription		Date	Verification	QC Inspector
oc/Data quip/Tooling perator laterial etup other rocess upplier raining															
							F	AUL	T CATE	GORY					
Landi	_	7			г		General		1		г	_		_	¬ !
		Bending Centre Not Concentric to O/S Cracks					Bend BOM/Route Broken/Damaged		4	ion Incomplete		Over/Under tolerance T Part Incorrect V			Pressure/Forced Temperature/Cure Weld
	Crushed/Crimped Burrs							<u> </u>	1	ions Incomplete/	'Unclear		art Lost/Mi	ssing	Wrong Stock Pulled
		Cuffs					Contamination	\vdash	Mainte		-	Part Moved			
•		Heat Trea	-	Tuba	-		Countersink	-	Mislabeled Positioned Wrong Misread Power Loss/Surge Other					Other	
		Inspection		eauı	}		Cut Too Short Drill Holes	-	Misread Offset	1	L		OWEL LOSS/S	Juige	Torres
		Ripples in	pena				ווווטן חטופט ווווטן	1	junset						

Out of Calibration
Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish Folio

Work Ord				*10!		Page 3					
Item ID: Revision ID: Item Name:	D3052-1 Mounting Lu	g		Accept	*N900	040	100)* s	Setup Sta	1/1	S1*
Start Date: Required Date Reference:	7/25/2013 :: 7/31/2013 RA 111569	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item ! Customer:						
Approvals:	vals: Process Plan: Date: Tooling: QC: Date: SPC (Y/N):					ate:		F	Run Sta Sto	"I V	R1* R2*
Sequence ID/ Work Center 1 250	D	Operation Description QC21- Final Inspection -	Work Order Release	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250 QC Quality Control		Мето		0.00				·- ·- ·	1CJ_)	1-07: MLJ 1	1-07

DQA:D	ate:
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NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

	•										QA Closed:	Da	ite:		
Work Ordei	·				DISPOSITION				AGAINST	DEI	PARTMENT	/PROCESS			
Part No					Rework Scrap		Skid-tube Crosstube Machining Small Fab				Water Jo			Engineering Quality	
NCR No	art No. CR No. Date Step Qty a poling r Bending Centre Not Concentric to O Cracks Crushed/Crimped Cuffs				Use-as-is Work Order Update		Thern	noforming Large Fab	Finishing Composite		Rec/Stoi	re/Packaging Supplier	-	Other	
Root				Descri	ption of work order update	Ir	nitial	Ac	ction		Sign &				
Cause	Date	Step	Qty	(or Non-conformance	Chi	ef Eng	Desc	cription		Date	Verificatio	n	QC Inspector	
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier															
Training	1														
Unapproved	``. 														
					F/	AUL'	T CATE	GORY							
Landin	g Gear				General				,		1			1	
 - -	Centre No		ntric to (o/s	Bend BOM/Route Broken/Damaged Burrs			ire ion Incomplete ions Incomplete,	/Unclear		Ovalized Over/Under Part Incorred Part Lost/Mi	ct		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled	
 					Contamination	-	Mainte				Part Moved		_]	
T I	Heat Trea	at			Countersink	-	Mislabe		1		Positioned V	Vrong			
ľ	Inspection		Tube		Cut Too Short	-	Misrea				Power Loss/	-		Other	
ľ	Ripples in			 	Drill Holes	П	Offset		•		•		-		
	Torque W	/aves in E	xtrusio	n	Drawing		Out of	Calibration							
Ī	Turning S	equence			Finish		Out of	Sequence							•
	Wave/Tw	e/Twist in Tube Folio Outside Dimensions													

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Picklist Print

Thursday, July 25, 2013 3:17:18 PM

Work Order ID:

105183

Parent Item:

D3052-1

Parent Item Name:

Mounting Lug

Comments:

IPP: A02.01.28New IssueNG

IPP: B Rev.B dwg 07-09-25 DD verified by EC

Start Date: 7/25/2013

Required Date: 7/31/2013

Page 1

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3052-1		Manufactured	No			· · · · · · · · · · · · · · · · · · ·	Each	17.0000		1			
Mounting Lug													an an same of the
				Location		Loc Qty	Lo	c Code					
				ST477		17							
				4020	00	17							

() 40200 () 40200

		DQA:	Date:	
NCR: Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			

	·								QA Closed:	Dat	te:			
Work Orde	r:				DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part N NCR N	o				Rework Scrap Use-as-is Work Order Update	Th	Skid-tube Machining ermoforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other			
Root				Descri	ption of work order update	Initia	I A	ction	Sign &					
Cause	Date	Step	Qty		or Non-conformance	Chief E	ng Des	cription	Date	Verification	n QC Inspector			
Doc/Data														
Equip/Tooling			1											
Operator														
Material [1												
Setup														
Other			1						ļ					
Process]											
Supplier														
Training			1							<u> </u>				
Unapproved														
					F	AULT CA	TEGORY							
Landir	ng Gear				General				1	,				
	Bending				Bend	Gra			Ovalized		Pressure/Forced			
	Centre N	ot Conce	ntric to C	D/S	BOM/Route	$\boldsymbol{\vdash}$	dware	<u> </u>	Over/Under		Temperature/Cure			
,	Cracks			ļ	Broken/Damaged	—	ection Incomplete	_	Part Incorre		Weld			
		/Crimped		<u> </u>	Burrs	_	ructions Incomplete	/Unclear	Part Lost/M	issing	Wrong Stock Pulled			
	Cuffs				Contamination	\vdash	intenance		Part Moved					
	Heat Tre			<u> </u>	Countersink	\vdash	labeled		Positioned V	_				
	—	on Strip in	Tube	<u> </u>	Cut Too Short	Misread Power Loss/Surge Other				Other				
	Ripples in Bend Drill Holes Offset													
	Torque Waves in Extrusion Drawing				\vdash	of Calibration								
	Turning !	Sequence	:	L	Finish		of Sequence							
	Wave/Tu	wist in Tul	he		Folio	I lOut	side Dimensions							

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RA 111569 D205-541-043 QTYx2

Received @ Dart July 18th, 2013 Inspected a Dart July 23rd, 2013

CUSTOMER: RETROLEUM HELICOPTERS INC CUSTOMER CONTACT: JULIA RAMOS SHIPPED FROM: LAFAYETTE LA, USA

Instructions for RA 111569 D205-541-043 B102568 CHG002

- Still at current CHG#
- Basket has been re verified as a Right Hand (-044)
- Kit has not been used. Can be reused as is
- Basket must be cleaned before restocking
- All Identification for previous B#'s must be removed
- D2332-041 must be removed and relocated on correct side
- Needs new BATCH # for restocking
- Needs new labels and paper works

Time Estimate

= 3 HOURS

Departments Required: Stores & Finishing

Pictures Attached = NO

QTY INSPECTED = x1 D205-541-041 B102568 CHG 002

Instructions for RA 111569 D205-541-043 B102569 CHG002

- Still at current CHG #
- Basket has been re verified as a Right Hand (-044)
- All hard ware has been used and needs to be replaced
- The "D" parts listed must be striped and re powder coated and re-id under original B#'s (see Eric Downing for re identifying)
 - o D2498 B55744
 - o D3052-1 B40200
 - o D2499 B55745
 - o D2199-23 B97098
 - o D2199-25 B98075
- Basket must be cleaned before restocking
- All Identification for previous B#'s must be removed
- D2332-041 must be removed and relocated on correct side
- Needs new BATCH # for restocking
- Needs new labels and paper works

Time Estimate ___ = 10 HOURS

Departments Required: Stores & Finishing

Pictures Attached = NO

QTY INSPECTED = x1 D205-541-041 B102569 CHG 002

												DQA:	Da	ite:	
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UF	PDATE					
												QA Closed:	Da	ite:	
Work Ord	or.					DISPOSITION				AGAINST D	ÞΕ	PARTMENT,	/PROCESS		
VVOIR OIG	CI.,					Rework	1		Skid-tube	Crosstube		Water Jet			Engineering
Part I	No.					Scrap	1	ľ	Machining	Small Fab		Pro	d. Eng. Coor.		Quality
						Use-as-is]	Therm	noforming	Finishing		Rec/Sto	re/Packaging	-	Other
NCR I	No.					Work Order Update		Large Fab Composite Supplier							
Root	_		1		Doccri	ption of work order update	Т,	Initial	Λ.	ction		Sign &			<u> </u>
Cause		Date	Step	Qty		or Non-conformance	1	nief Eng		cription		Date	Verificatio	เก	QC Inspector
Doc/Data	П	Date	эсер	Qty	`	or itom comormanec	+	ner eng	563	cription			7 0111104110		До шорового
Equip/Tooling	H		ĺ												
Operator															
Material															
Setup															
Other															
Process															
Supplier	_														
Training	\vdash												<u> </u>		
Unapproved			1				-	T CATE	CORY			<u> </u>	<u> </u>	—	
Land	ina (r General	AUI	LT CATE	GURT	<u> </u>					
Land	LIIB (Bending				Bend	Г	Grain		Г		Ovalized			Pressure/Forced
	\vdash	Centre N	ot Conce	ntric to	o/s	BOM/Route	\vdash	Hardwa	ire	ŀ		Over/Under	tolerance		Temperature/Cure
Cracks						Broken/Damaged	一	-1	ion Incomplete	ŀ	-	Part Incorre			Weld
		Crushed/	Crimped			Burrs		-i '	ions Incomplete	e/Unclear		Part Lost/M	issing		Wrong Stock Pulled
		Cuffs	•			Contamination		Mainte	enance			Part Moved			•
		Heat Tre	at			Countersink		Mislabe	eled			Positioned V	Vrong	_	_
		Inspectio	n Strip in	Tube		Cut Too Short	Г	Misread	d			Power Loss/	Surge	1	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

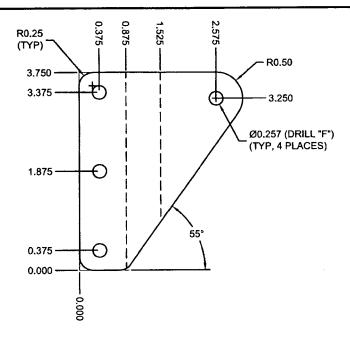
Drill Holes

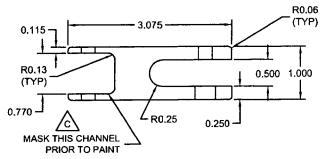
Drawing

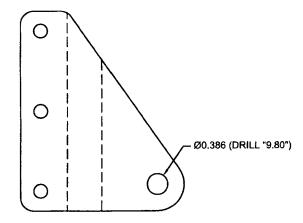
Finish

Folio

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o7.08-29

D3052-1 MOUNTING LUG

NOTES:

1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)

PER AMS-QQ-A-200/8 (OR AMS 4160)

(REF. DART SPEC. M6061T6B)

2) FINISH: CHÉMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3052-1" USING FINE POINT PERMANENT INK MARKER

7) WEIGHT: 0.44 lbs

В	- DUE	D MASKING TO TIGHT FIT MASKING STI	DC	07.07.25							
Α	NEW IS	SSUE		RF	01.11.01						
REV.			DESCRIPTION	BY	DATE						
DESIGN		→	DART AEROSP	DART AEROSPACE LTD							
DRAWN		SC	HAWKESBURY, ONTA	RIO, CAN	ADA						
CHECK	ED	40	DRAWING NO.	REV. B							
MFG. AF	MFG. APPR.		D3052	:	SHEET 1 OF 1						
APPRO'	APPROVED A		TITLE								
		142/	┥								

DE APPR.

MOUNTING LUG

1:2

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